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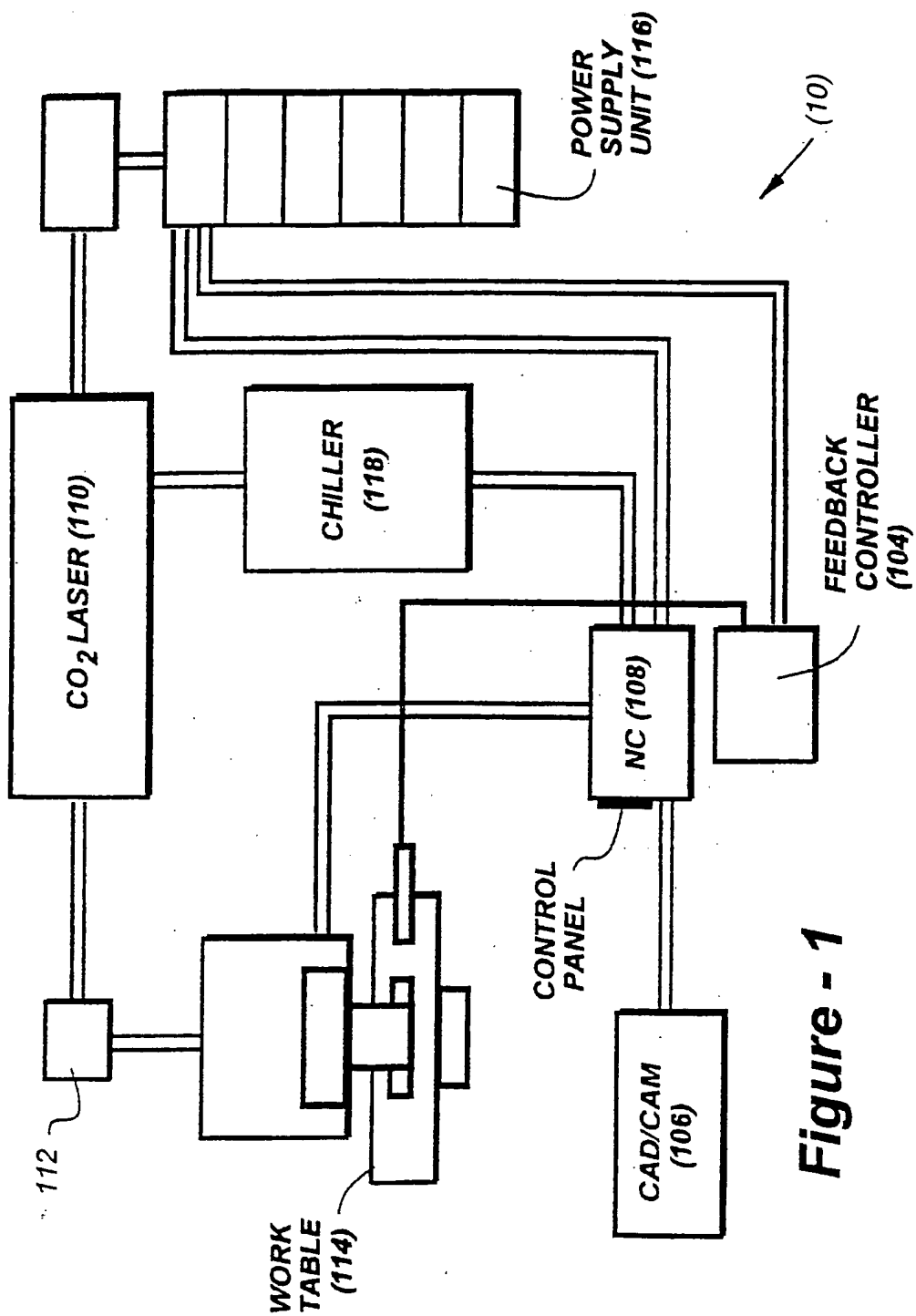


Figure - 1

Figure - 2

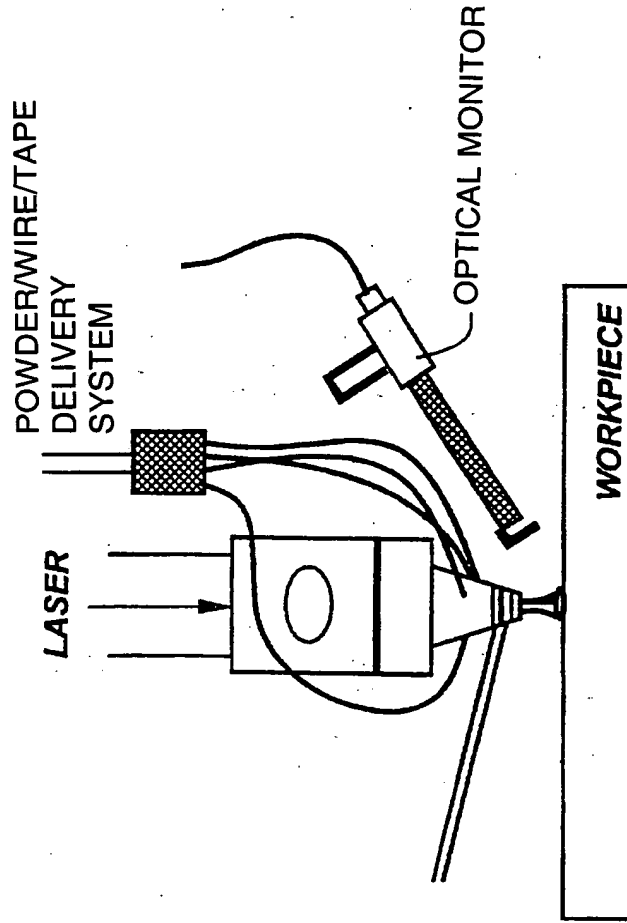




FIGURE 3

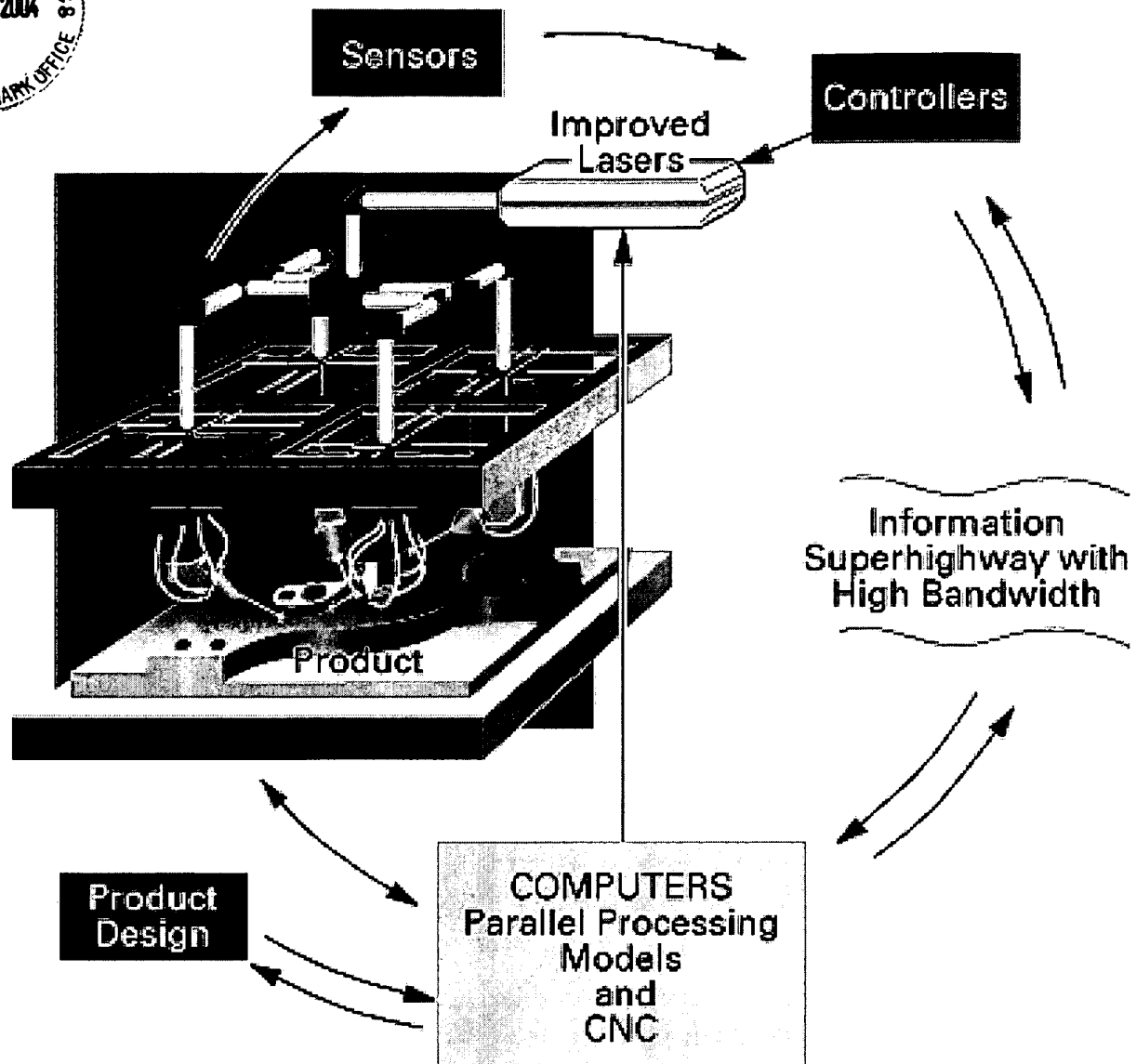


FIGURE 4

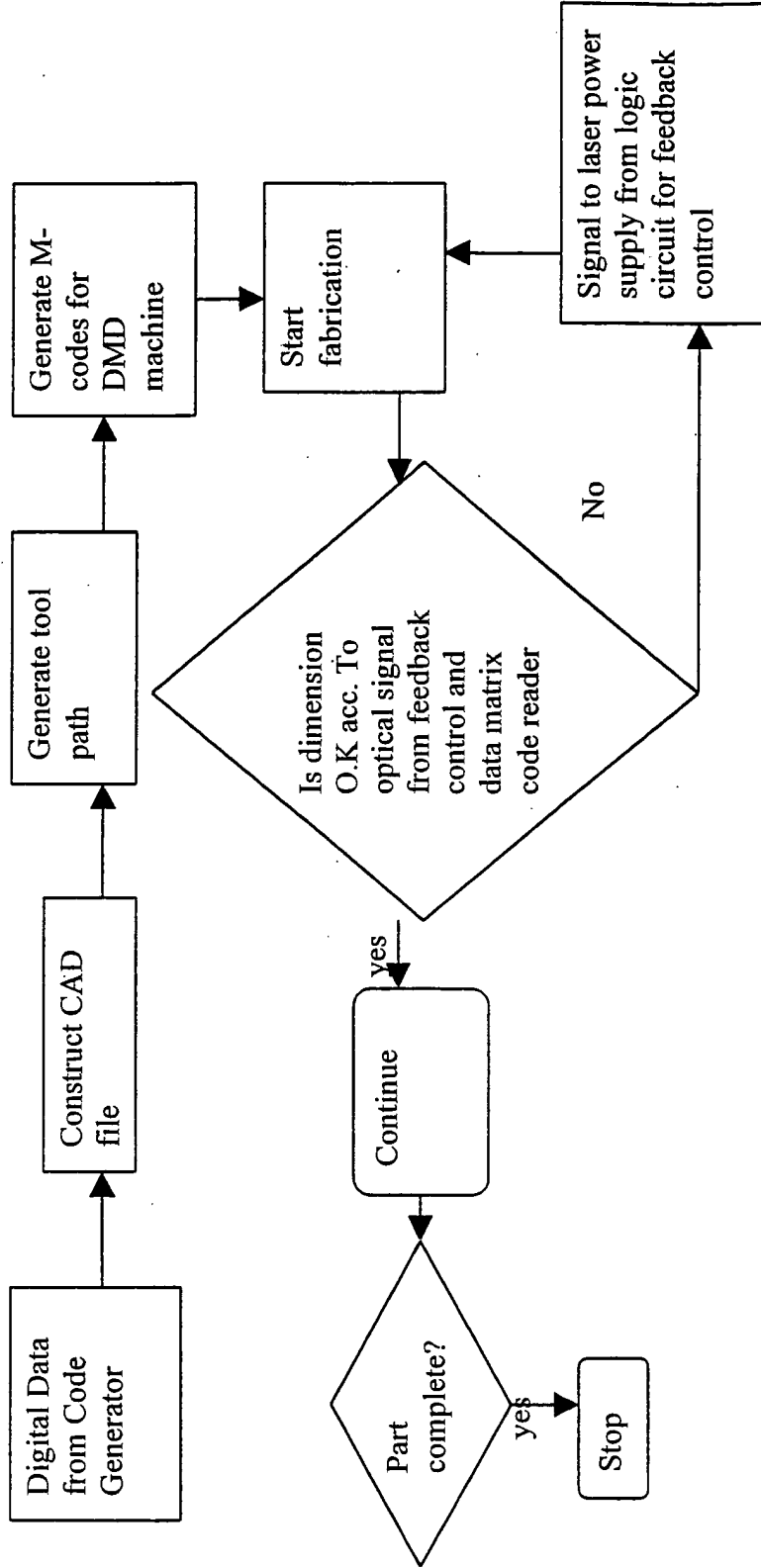


FIGURE 5

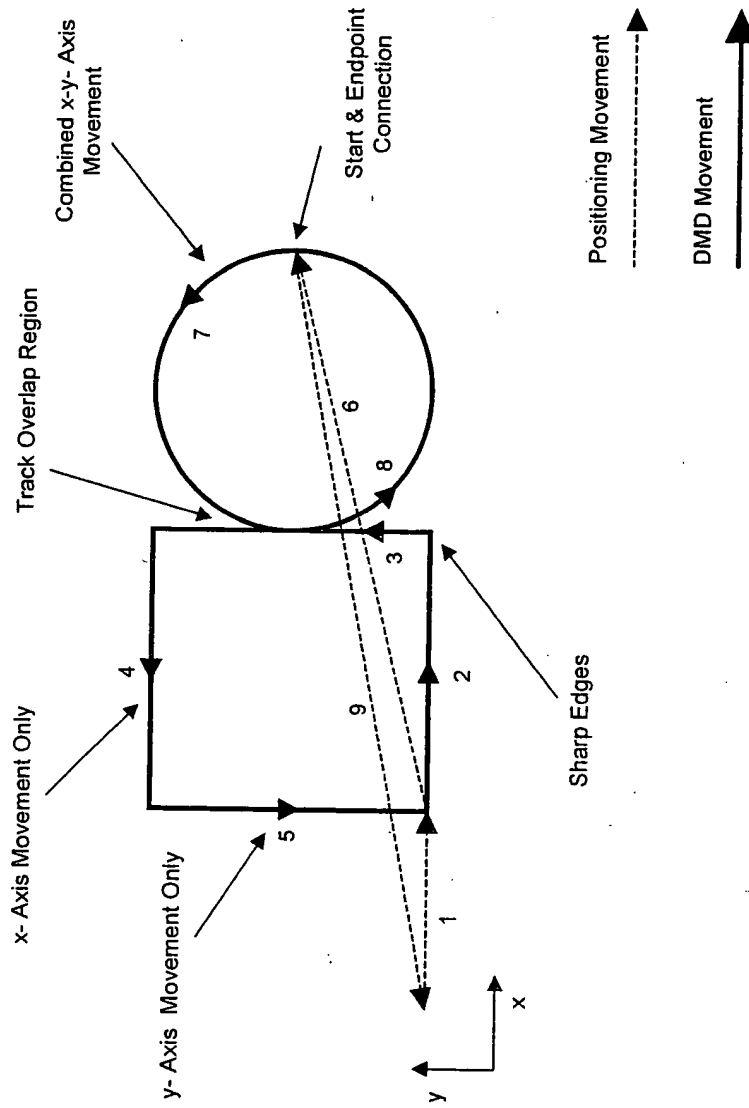


FIGURE 6

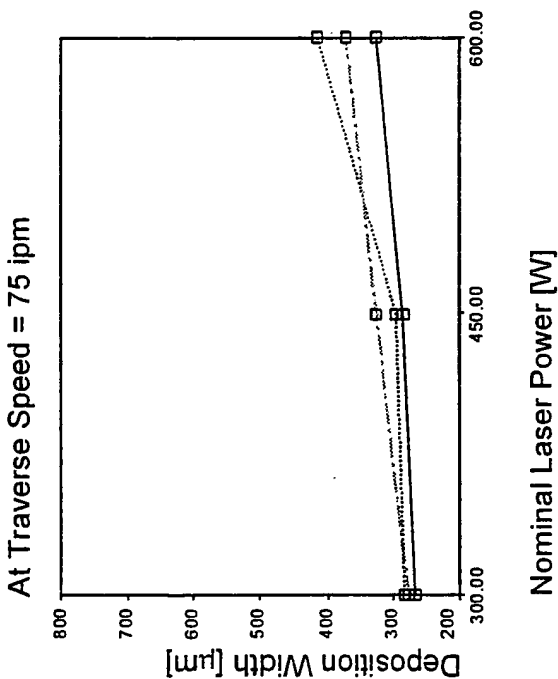
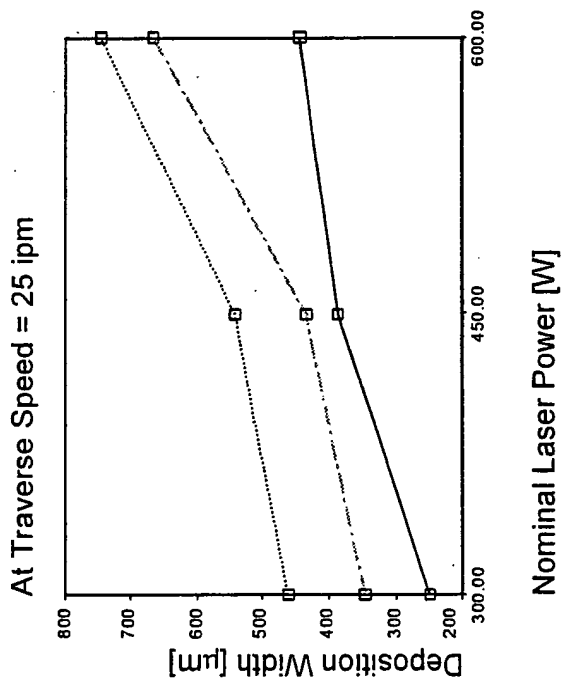
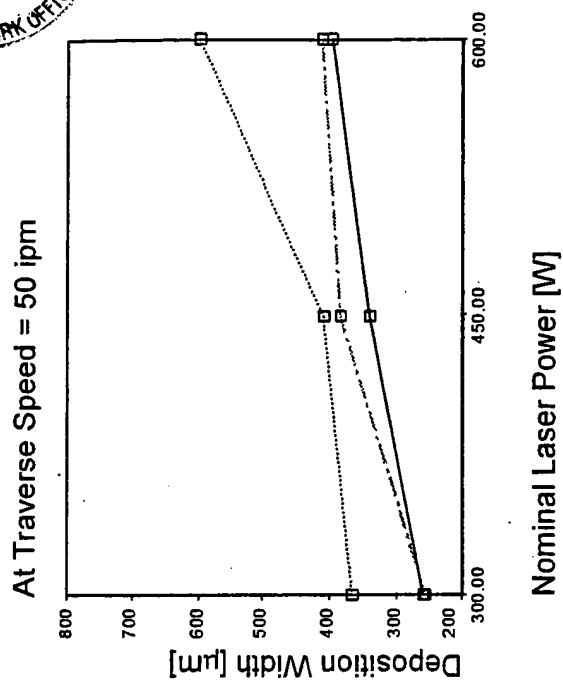
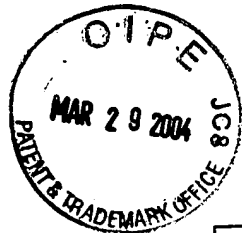
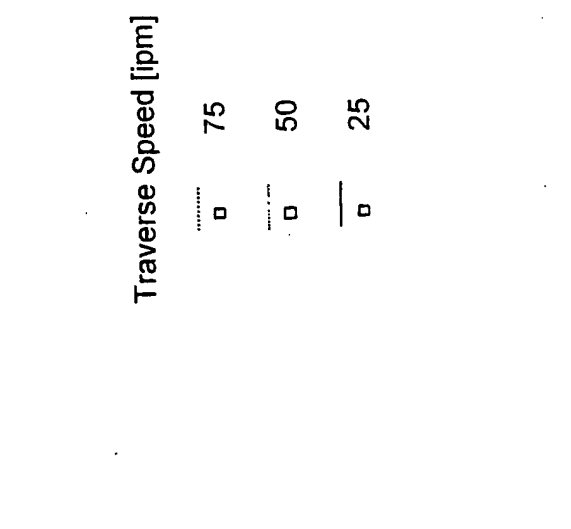
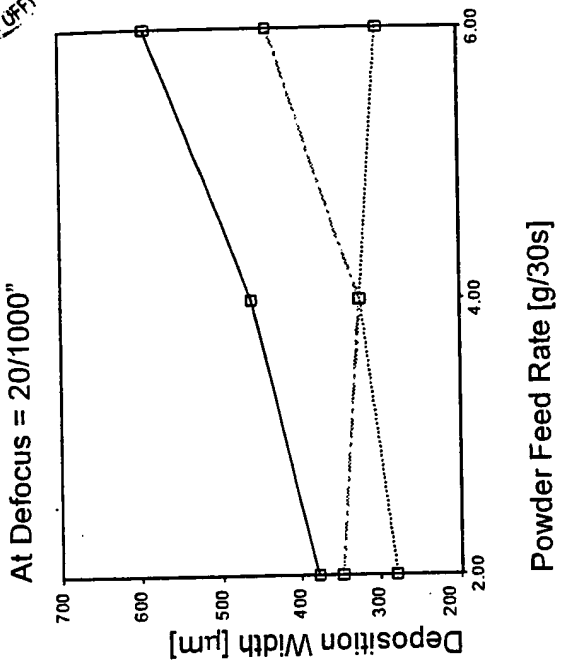


FIGURE 7

PATENT & TRADEMARK OFFICE
MAR 29 2004



Traverse Speed [ipm]

75
50
25

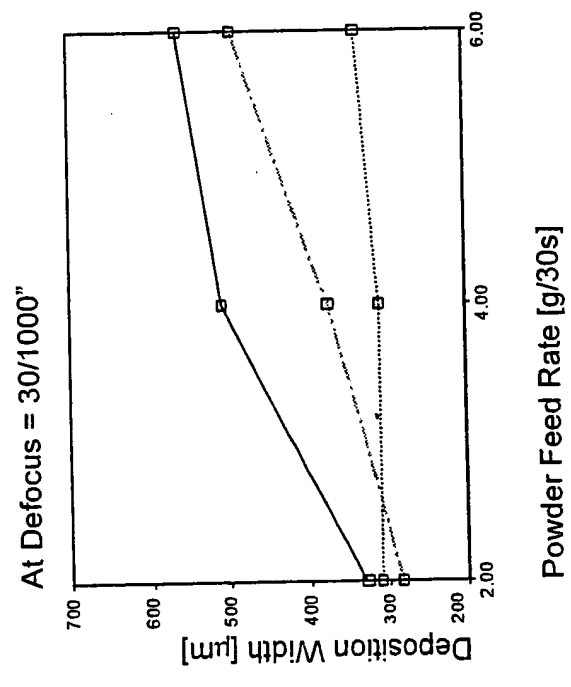
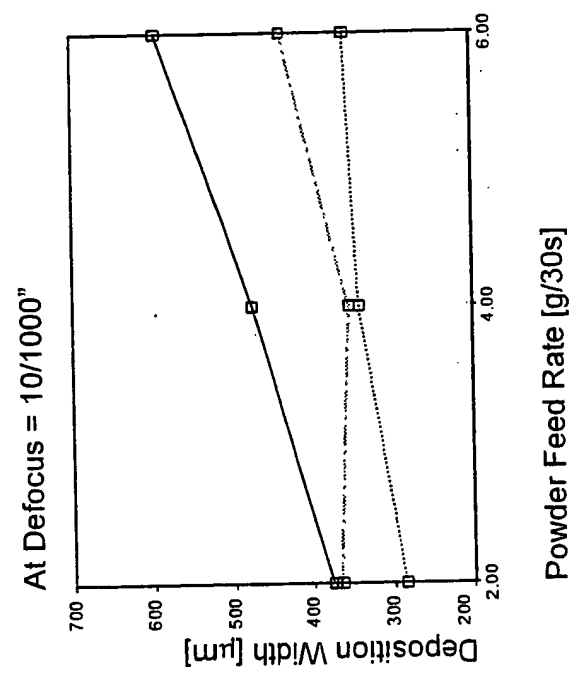
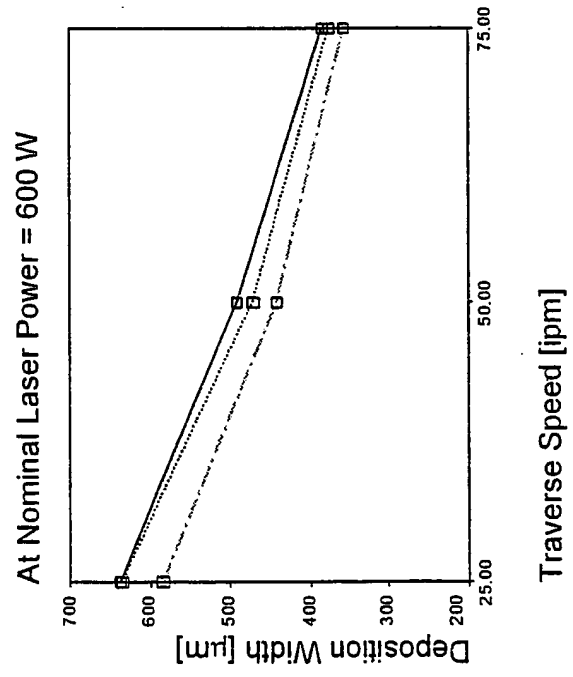
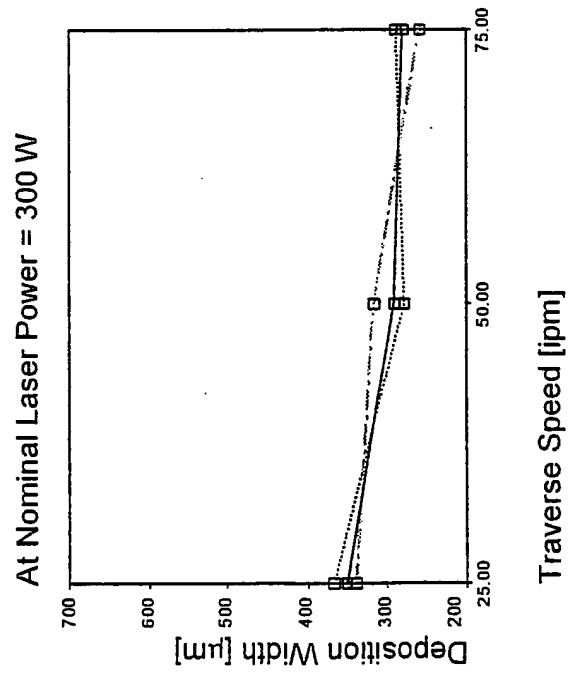
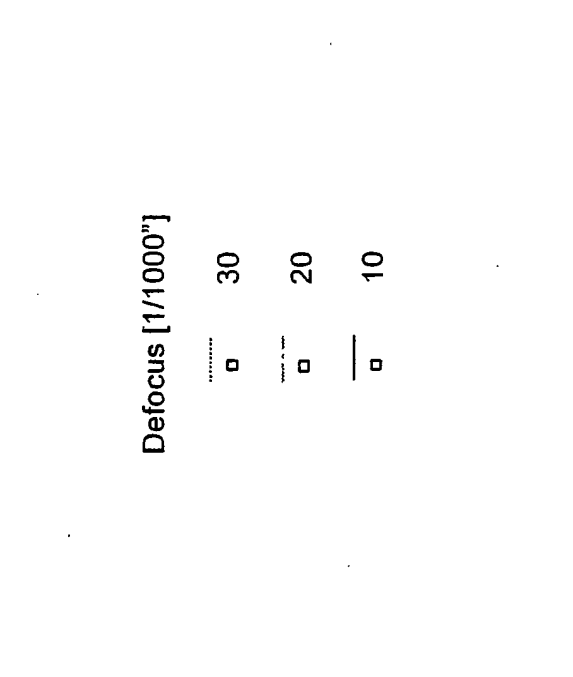
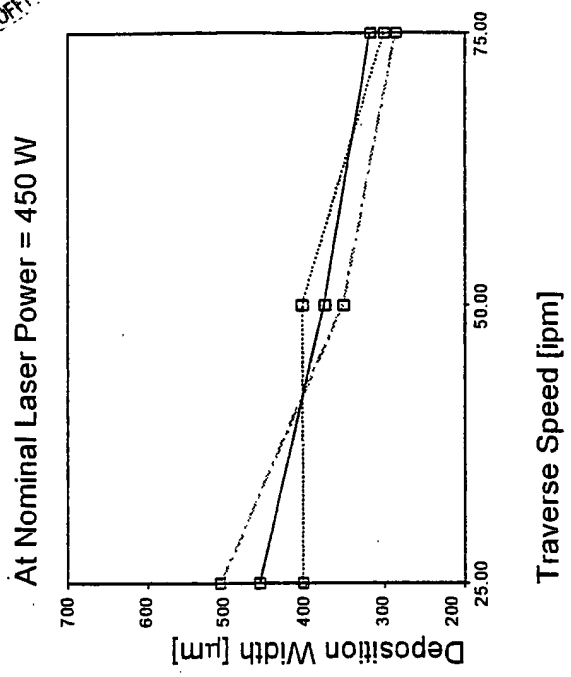


FIGURE 8



Defocus [1/1000"]

□ 30

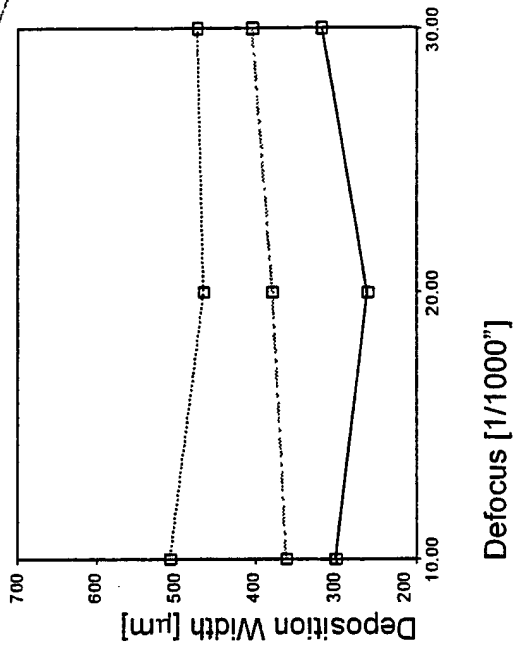
□ 20

□ 10

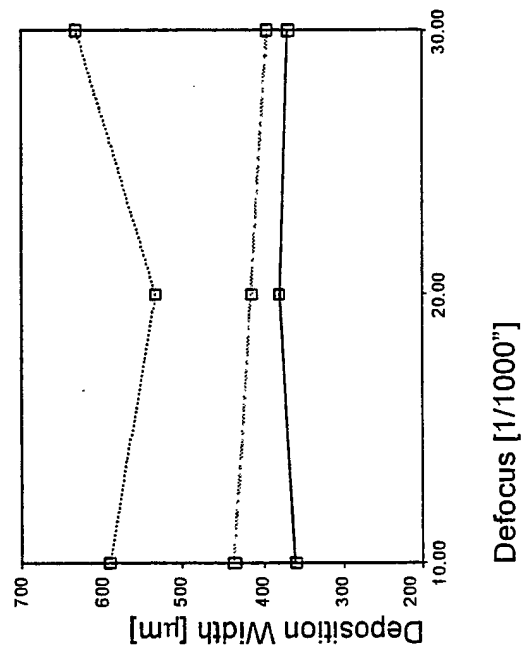
FIGURE 9



At Powder Feed Rate = 4 g/30s



At Powder Feed Rate = 6 g/30s



Nominal Laser Power [W]

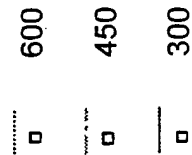


FIGURE 10

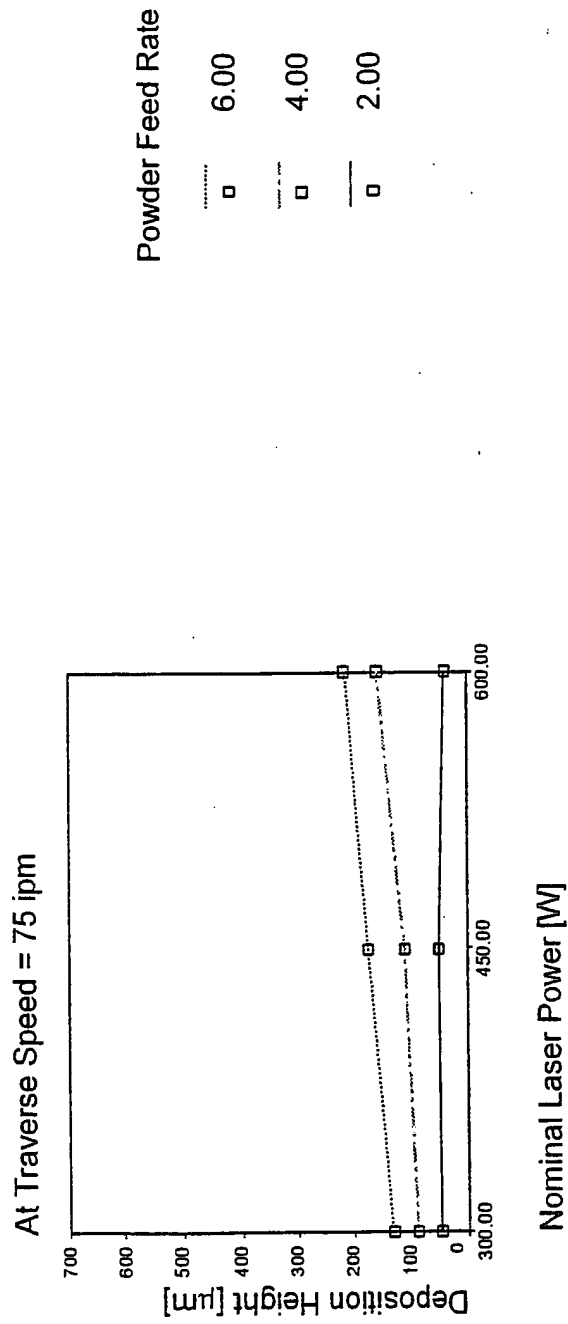
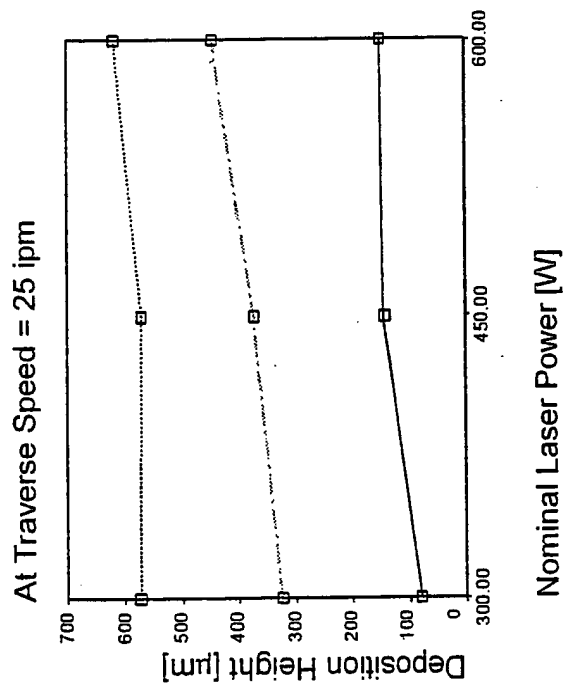
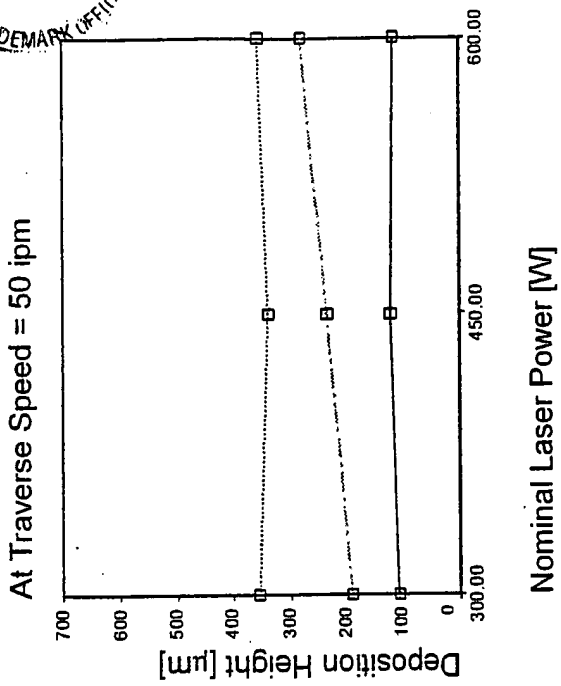
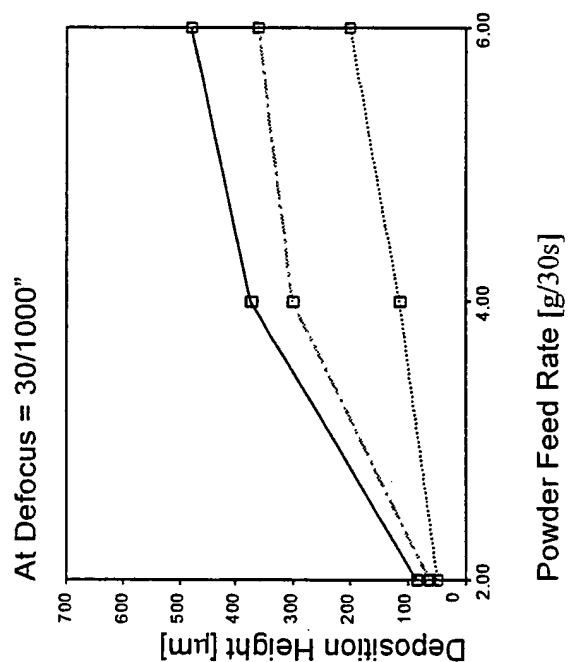
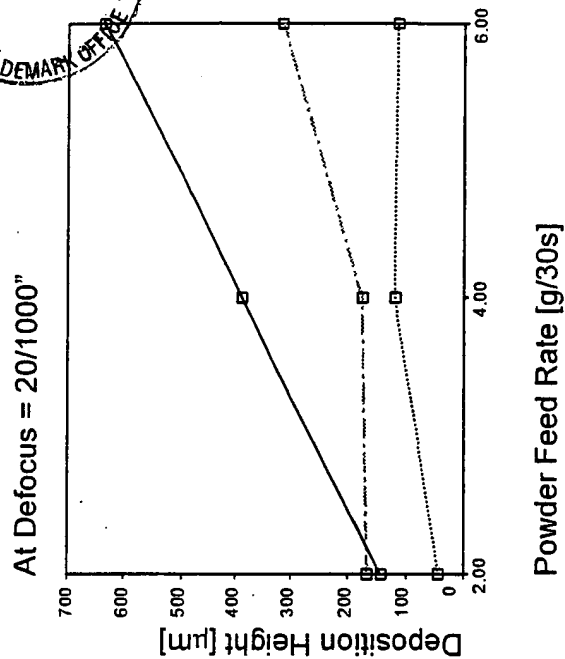
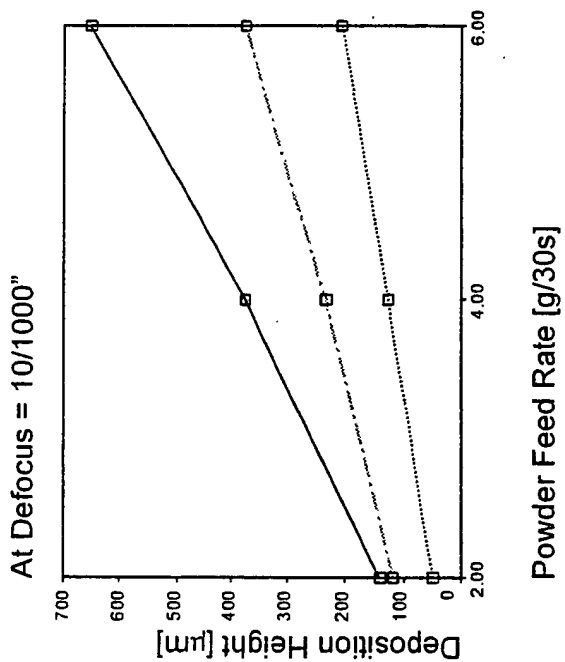
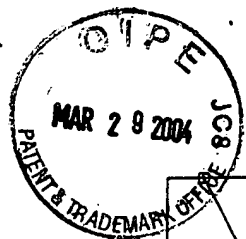


FIGURE 11



Traverse Speed [ipm]

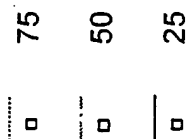
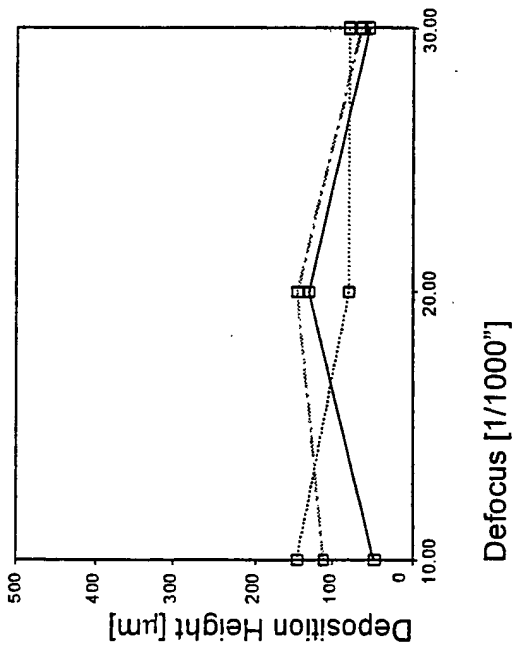


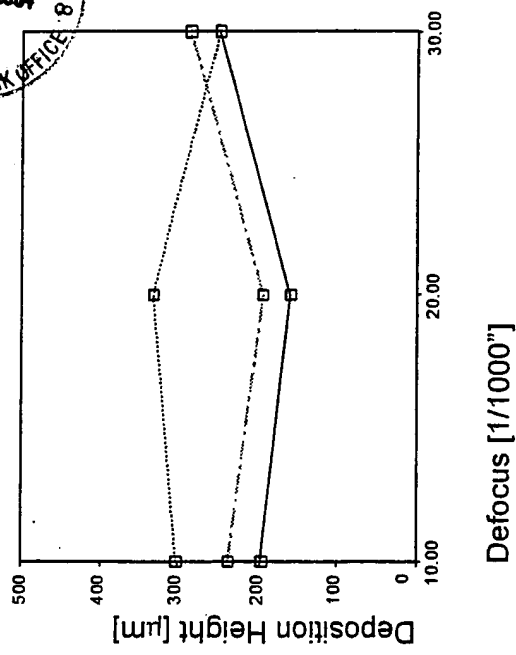
FIGURE 12



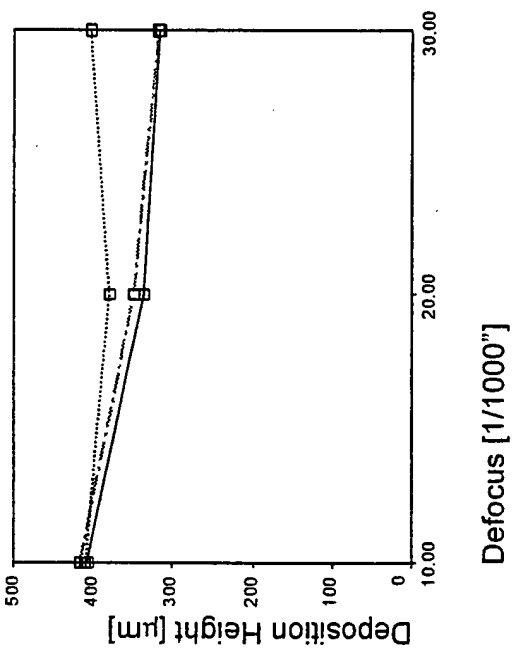
At Powder Feed Rate = 2 g/30s



At Powder Feed Rate = 4 g/30s



At Powder Feed Rate = 6 g/30s



Nominal Laser Power [W]

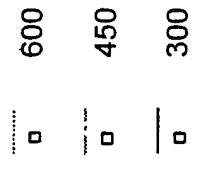


FIGURE 13

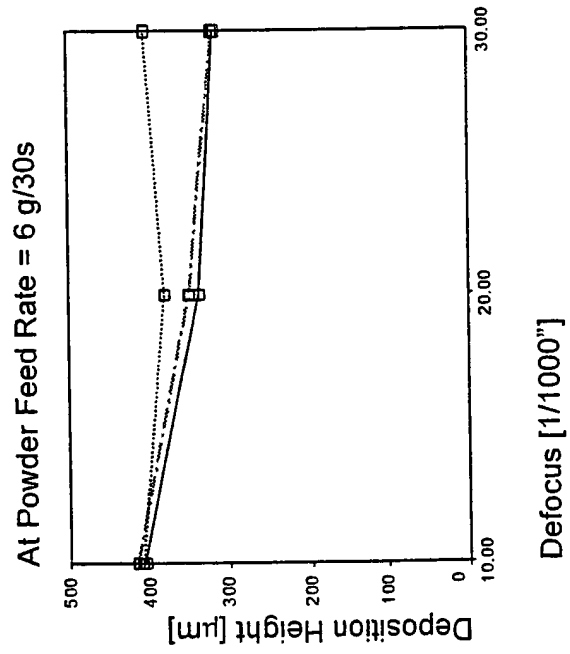
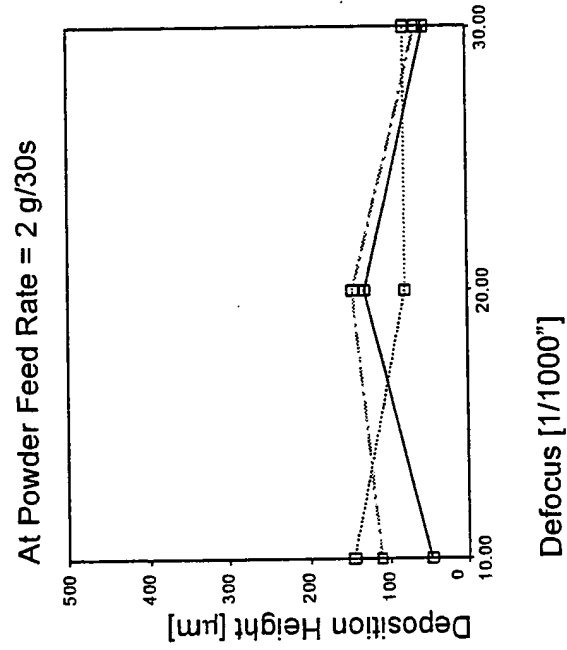
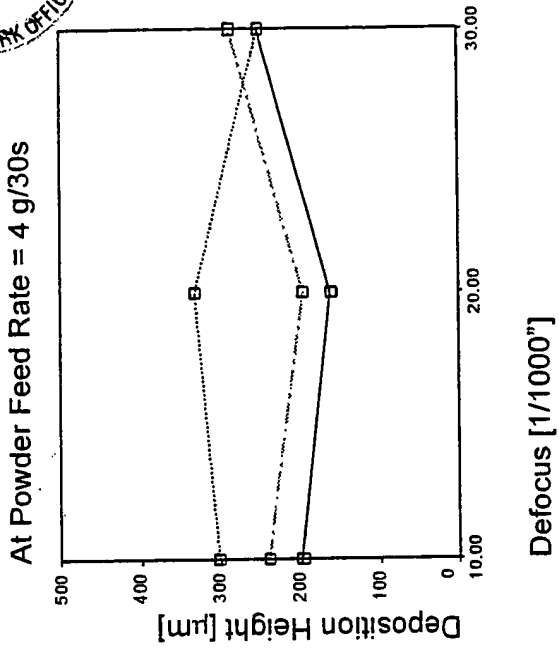
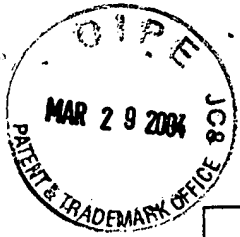


FIGURE 14